

Date: Monday, 12/10/2007 12:00:33 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 36213
 Estimate Number : 12279
 P.O. Number :
 This Issue : 12/10/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : LARGE FAB ASSY
 Previous Run : 34667

Drawing Name : ~~RIGHT ARM WELDMENT~~

Part Number : D3354041

Drawing Number : D3354 REV ~~8C~~

Project Number : N/A

Drawing Revision : ~~8C~~

Material :

Due Date : 12/24/2007

Qty: 2

Um: Each

Written By :

Checked & Approved By :

Comment :

est rev. A 06.02.09 new issue EC
 est B 07.05.14 rev B dwg EC

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

D33549

handle socket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-9	Handle socket	B31384 → 2x

1x B31304 2x 42498

JL 07/12/11

2.0

D33541

inner shaft

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-1	Inner shaft	B36231 → 2x

B36231 x 3

EL 9-1-7

JL 07/12/11

3.0

D33547

left arm plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-7	Left arm plate	B37303 → 2x

B42497 x 3

EL 9-1-7

JL 07/12/11

4.0

D33543

shaft

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-3	Shaft	B31560 → 2x

B42763 x 3

EL 9-1-7

JL 07/12/11

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 36213

Part Number: D3354041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

TP-134 TENSION PIN

Batch: M116562

3X ✓

~~07/12/11~~

EL

9-1-7

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg D3354 ✓

2-Grind welds flush as per dwg D3354 ✓

~~07/12/11~~

EL 9-1-7 3

7.0

QC9

VISUAL WELDING INSPECTION



(X3)



Comment: VISUAL WELDING INSPECTION

09-01-08

~~07/12/11~~ (3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

50961/08 (43)

9.0

POWDER COATING

POWDER COATING



M18052



(3X)

Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

m-1

09/01/09

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

2-m 09-01-10 (3)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 484

9/1/12

3X
50

200

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 36213

Part Number: D3354041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/13 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

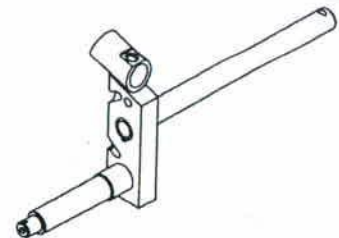
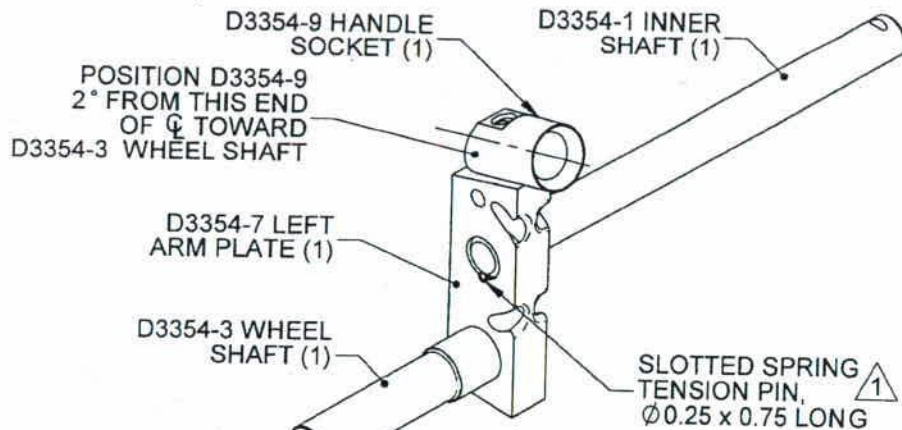
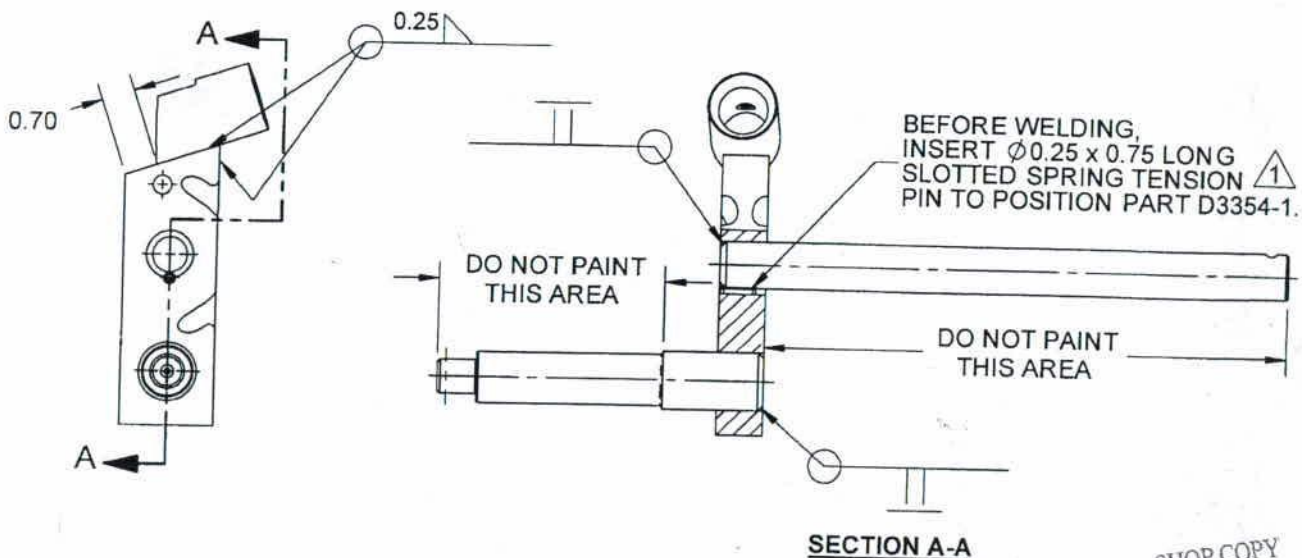
Job Completion



MF 09-01-12

DARTRELEASED
07/12/06

DESIGN <i>RF</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>lb</i>	APPROVED <i>WJ</i>	DRAWING NO. LEFT ARM WELDMENT	REV. C SHEET 1 OF 7
DATE 07.12.06		TITLE D3354	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	
C	07.12.06	CHANGE TOLERANCE ON D3354-7 LEFT ARM PLATE HOLE FOR D3354-3 WHEEL SHAFT	

**D3354-042 MIRROR ARM WELDMENT****D3354-041 LEFT ARM WELDMENT****NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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NO. **36213**

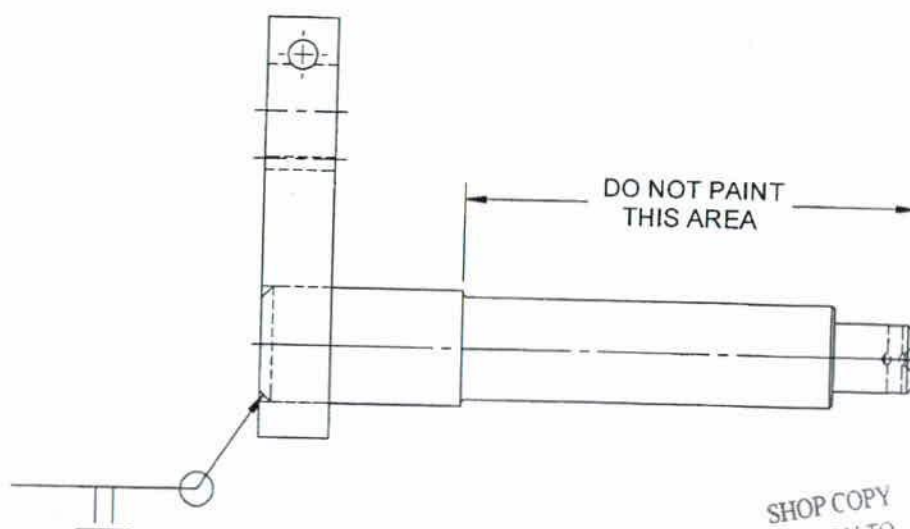
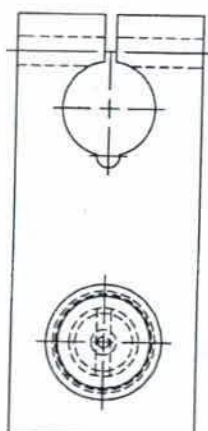
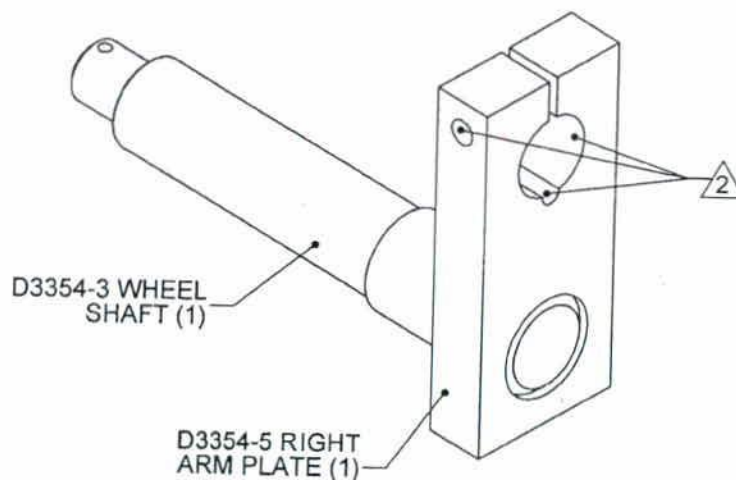
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DATE 07.12.06		DRAWING NO. D3354
		TITLE LEFT ARM WELDMENT
		REV. C SHEET 2 OF 7 SCALE 1:2

RELEASED
07/12/07 *WP*



D3354-043 RIGHT ARM WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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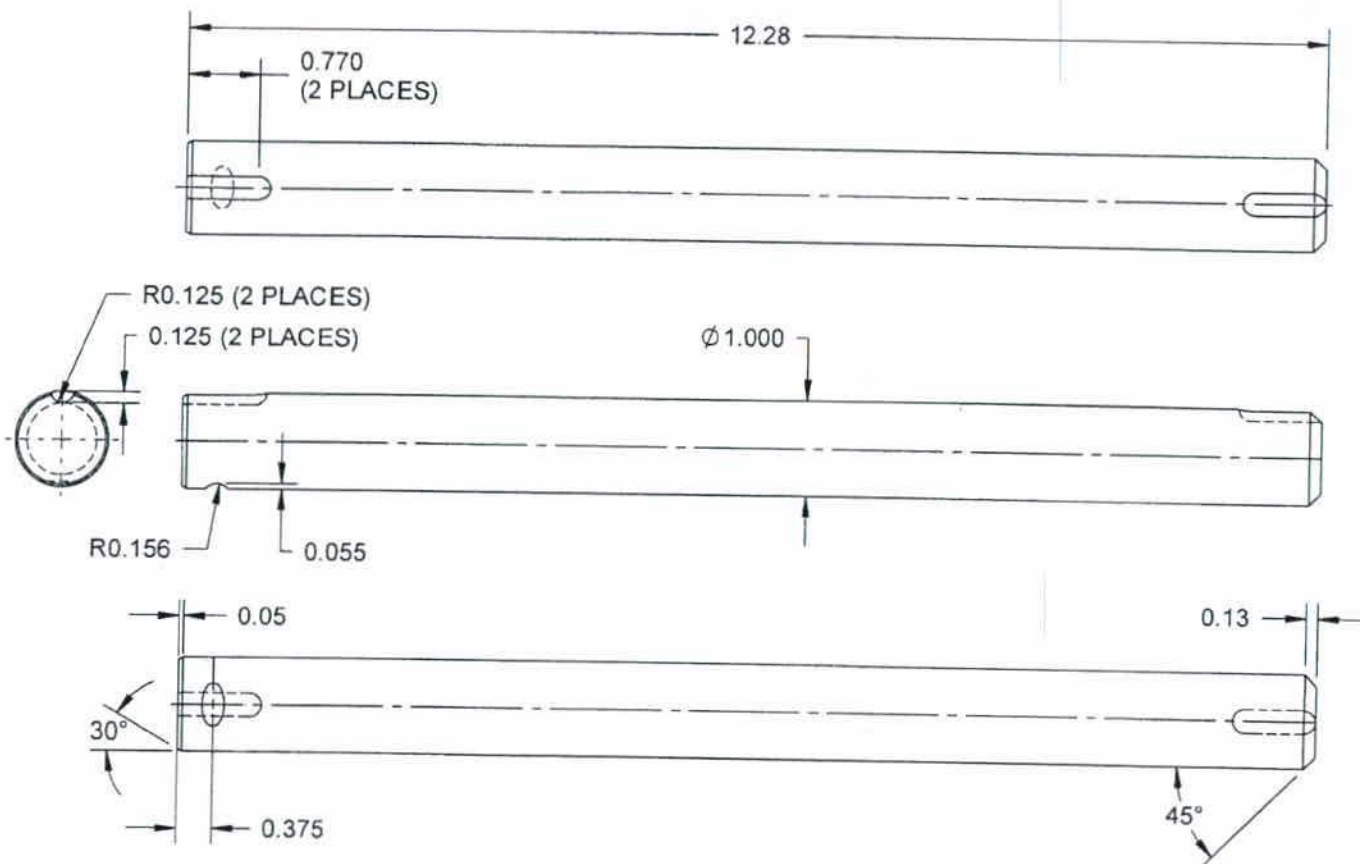
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3354	REV. C SHEET 3 OF 7
DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
07/12/07



D3354-1 INNER SHAFT

NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91
OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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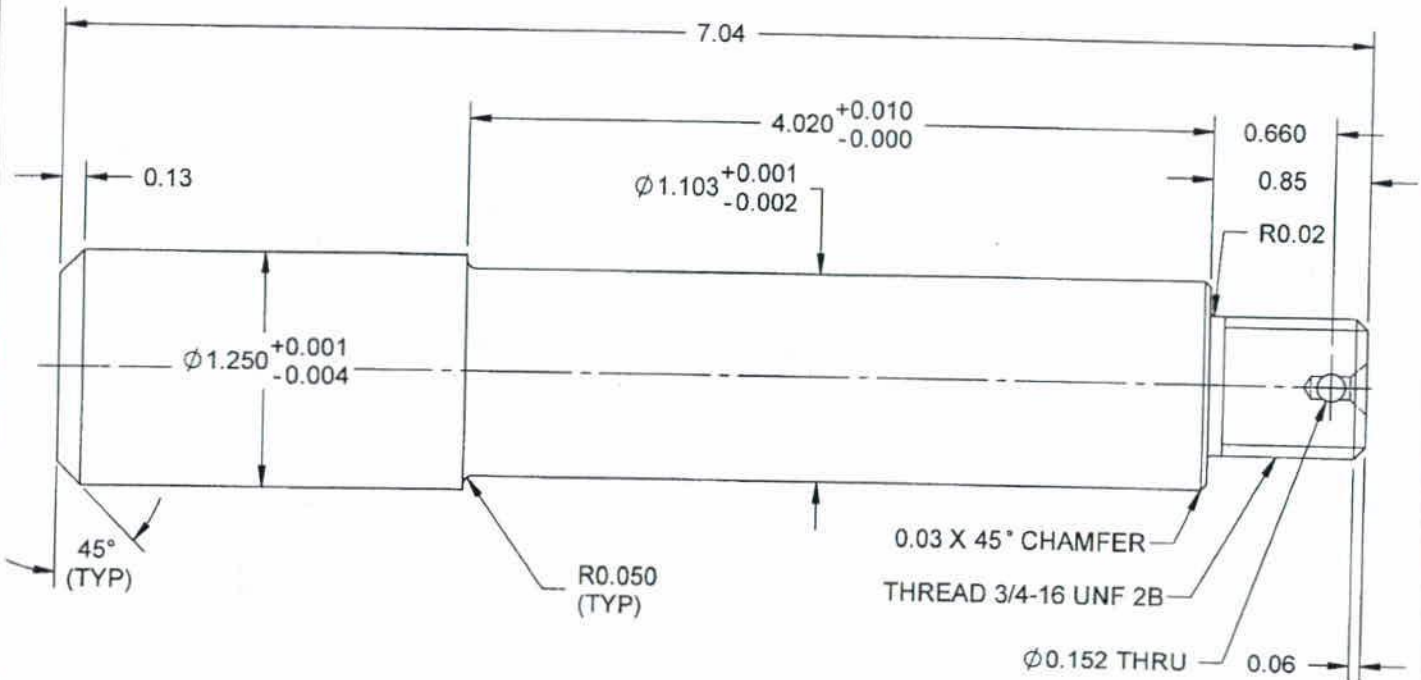
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DATE 07.12.06	TITLE LEFT ARM WELDMENT		SCALE 1:1

RELEASED
07.12.07 *[Signature]*



D3354-3 WHEEL SHAFT

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NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

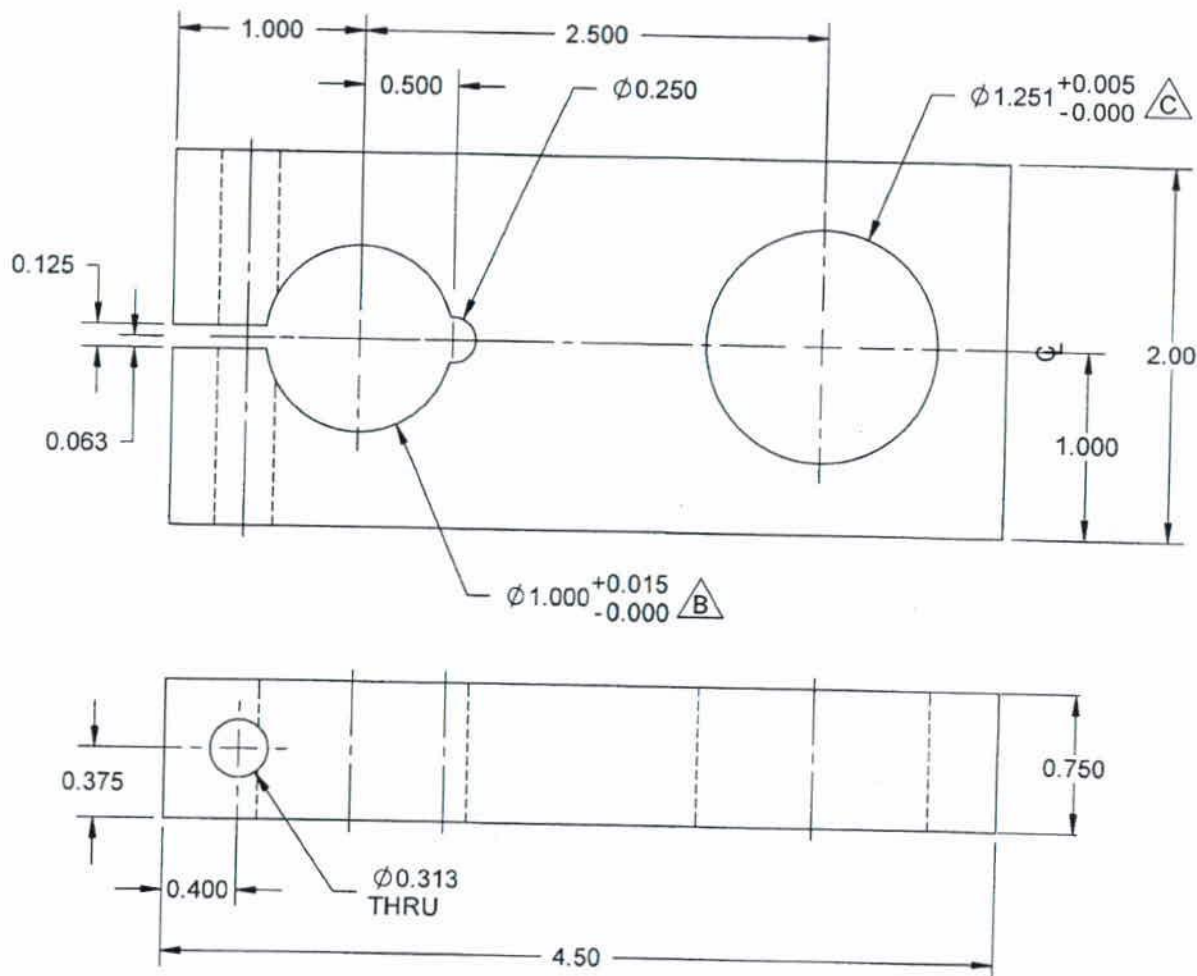
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SHEET 5 OF 7
			SCALE 1:1

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07/12/07 *[Signature]*



D3354-5 RIGHT ARM PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

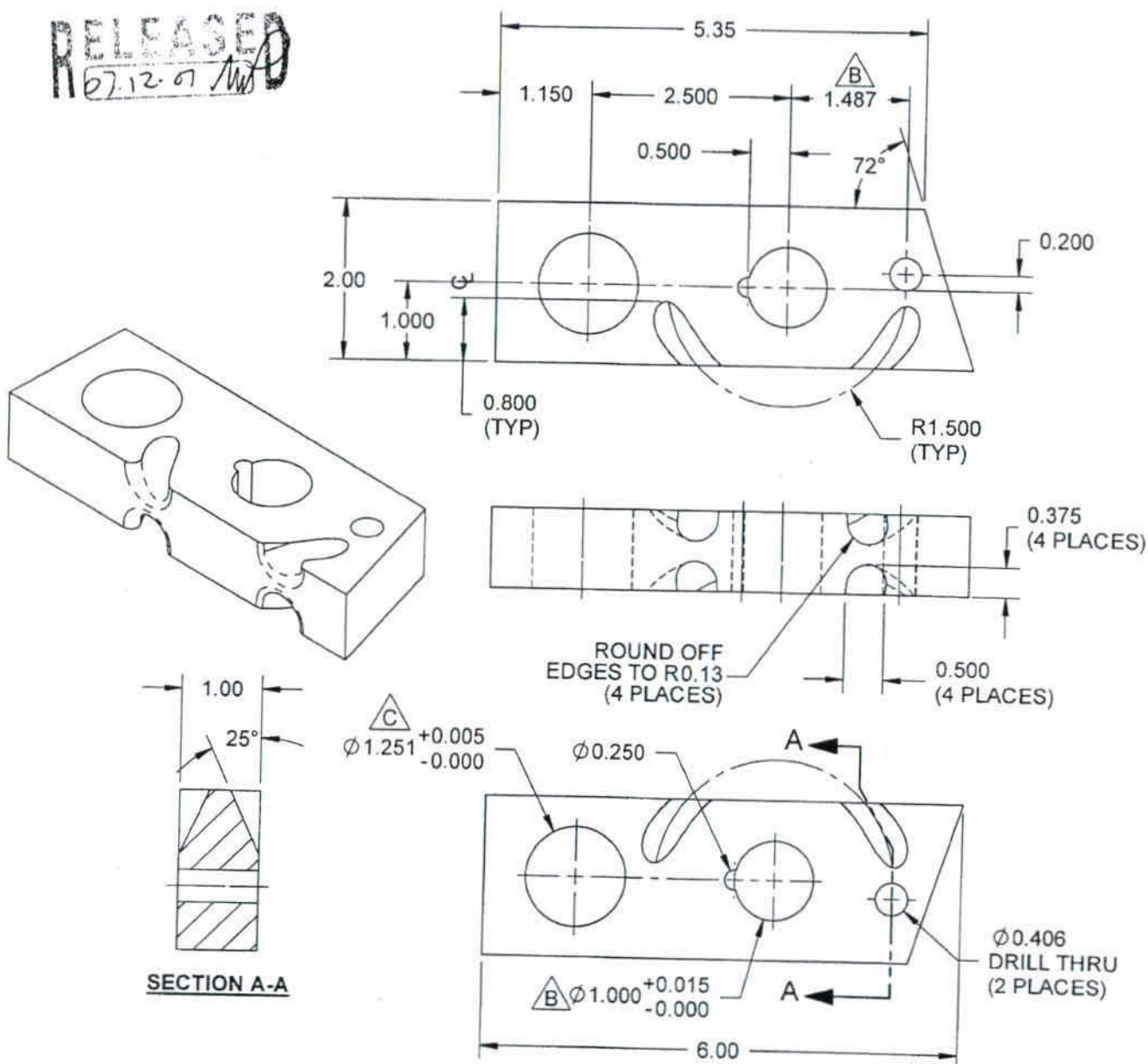
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DATE 07.12.06	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
07.12.07 *[Signature]***D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

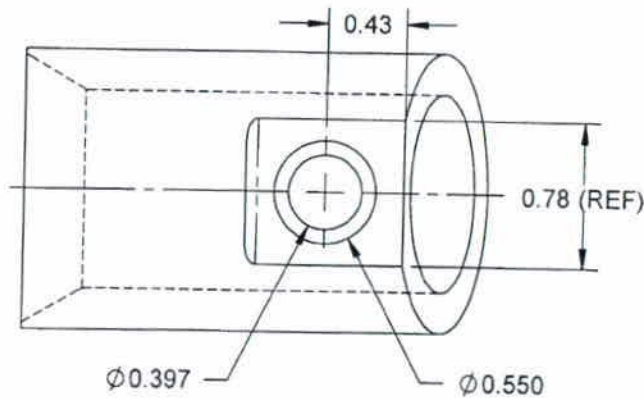
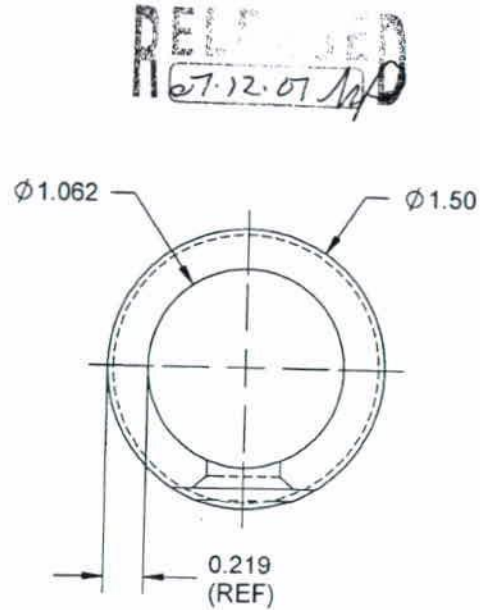
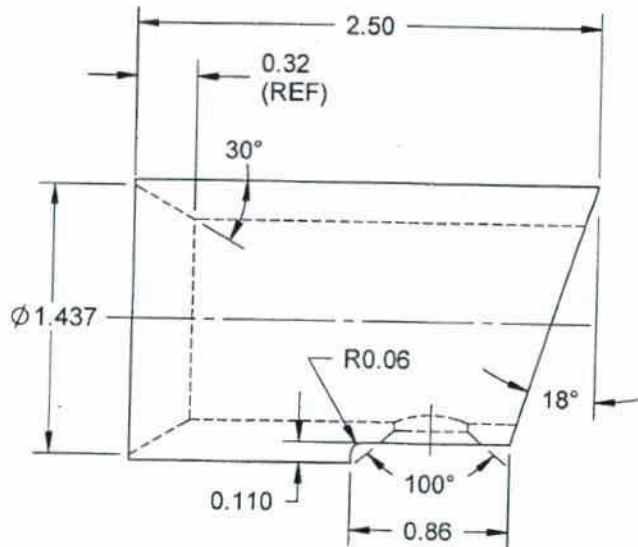
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DATE 07.12.06	TITLE LEFT ARM WELDMENT		SHEET 7 OF 7
			SCALE 1:1



D3354-9 HANDLE SOCKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAM LESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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